

**Work Order ID 60841**

Monday, July 26, 2010 10:28:52 AM

Page 1

Item ID: DSK081

Accept

Revision ID:

Item Name: D2940-1 TURNING DETAIL

Start Date: 7/26/2010 Start Qty: 4.00

Required Date: 7/30/2010 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

Date: 10-7-20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSK081

Rev A

100



Doosan

Doosan Lathe

MORI SEIKI CNC LATHE LARGE

Memo

Turn blank as per Folio FA079

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

SL 10/08/03

SL 10/08/03

SL 10.8.4

⑥

⑥

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60841**

Monday, July 26, 2010 10:28:52 AM



Page 2

Item ID: DSK081

Accept



Setup Start



Revision ID:

Stop



Item Name: D2940-1 TURNING DETAIL

Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

0.00

Packaging

Memo

Packaging

Identify and Stock in Kanban ☐ Location: CNC

up 10.8.4

⑥

140

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

10/08/05

ME 10-08-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 26, 2010 10:28:56 AM

Page 1

Work Order ID: 60841



Parent Item: DSK081



Parent Item Name: D2940-1 TURNING DETAIL

Start Date: 7/26/2010

Required Date: 7/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-007

Manufactured

No

Each

10.0000

1

4



Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT43

10

— 53752

10

6 SA 10/08/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	60841
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	6
Lathe Section									
A	3.211	3.216		3.214	3.213	3.213	3.213	3.215	3.214
B	4.946	4.966		4.960	4.957	4.957	4.957	4.957	4.957
C	0.718	0.738		.726	.726	.726	.726	.726	.726
D	0.090	0.110		.100	.100	.100	.100	.100	.100
E	3.564	3.584		3.575	3.575	3.574	3.575	3.574	3.5745
F	0.022	0.042		.032	.032	.032	.032	.032	.032
G	3.444	3.464		3.455	3.454	3.454	3.454	3.454	3.454
H	0.112	0.132		.120	.120	.121	.120	.118	.117
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.460	4.460	4.460	4.459	4.459	4.460
K	0.413	0.433		.427	.424	.424	.424	.424	.424
L	0.913	0.933		.927	.924	.924	.924	.924	.924
M									
N									
O									
P									

Measured by: SA/JL Date: 10/08/02

Audited by: MP Date: 10.8.4

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	SA

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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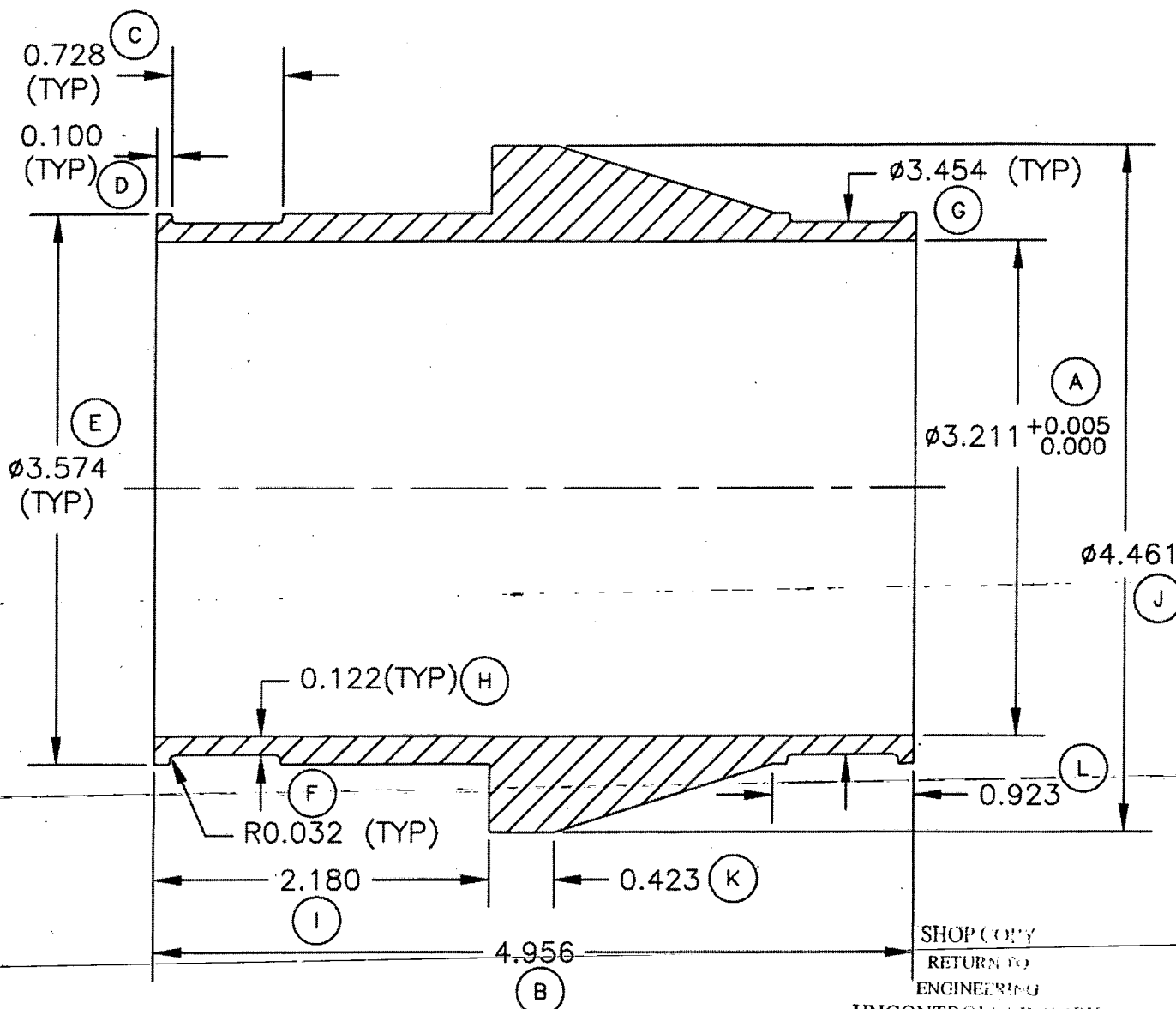
**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED  
03-07-01 *[Signature]*



D2940-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *60891*

*[Handwritten signature]*

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